

Date: Wednesday, 11/03/2009 12:58:53 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 46435	
Estimate Number : 10178	
P.O. Number :	Part Number : D25941
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D2594 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 43884	Material :
Written By :	Due Date : 04/04/2009 Qty: 200 Um: Each
Checked & Approved By : <u>SD 09.03.11</u>	
Comment : Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0547 f(s)/Unit Total : 10.9410 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch <u>M110230</u> <u>SD 09/03/15</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. <u>SD 09/03/15</u> <u>215</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SD 09/03/15</u> <u>215</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>H.A</u> <u>09/03/19</u> <u>(215)</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 <u>1 MD / BK</u> <u>09/03/19</u> <u>(215)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m110939

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

Umd / FL

(X215)

09/03/24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-24

(215)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-A

FL 09/03/24

(215)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

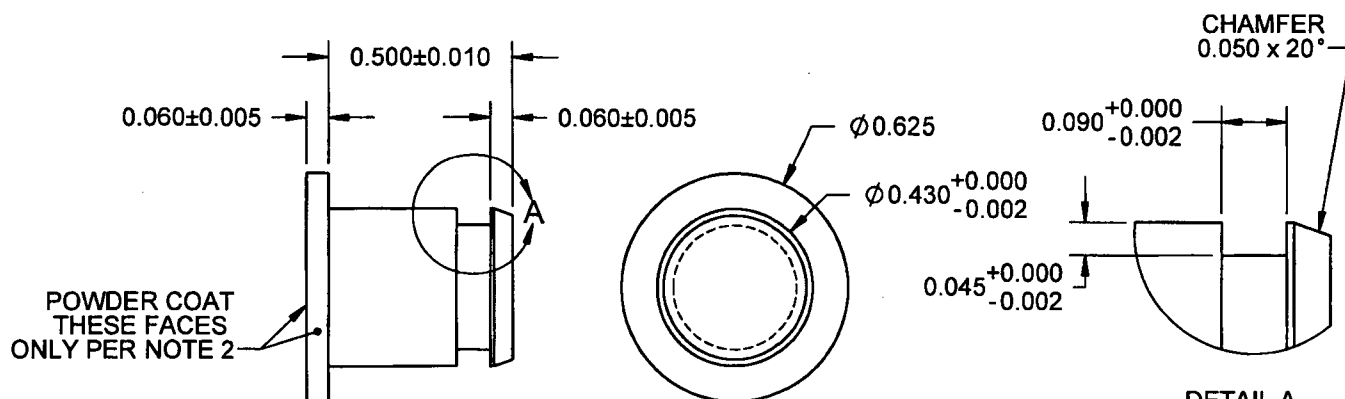
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 \triangle
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

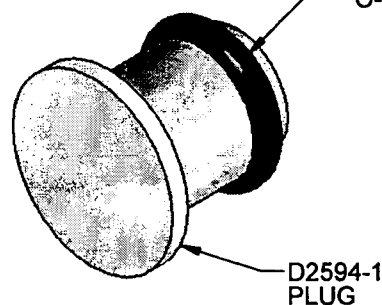
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 \triangle

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46135 D2594-3
O-RING

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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